



Dart Aerospace Ltd.
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D2806-3**Job Sheet 196314****Part No:** D2806-3**Job Qty:** 20 pcs**Part Name:** Bushing**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 6/11/19**Job Tracking No:****Due Date:** 7/12/19**Created By:** Marie Lajeunesse**Type:** Stock**Description:****Note:** DWG REV A IPP: B 05.03.11 Part now turned KJ/JLM IPP Rev:C Now on Doosan Lathe JLM Verified By:EC**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Doosan - 1	20 pcs		7/12/19	1.00	1.73	Doosan - 1		
120	QC 8	20 pcs		7/12/19	0.00	0.00	QC 8 - 12		 JUN 19/2019
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
130	Handfinish - 1-1 Chemical-B4B	20 pcs		7/12/19	0.00	0.30	Handfinish - 1 - 1 - B4B		 JUN 19 2019
							Handfinish - 1 - 2 - B4B		
							Handfinish - 1 - 3 - B4B		
							Handfinish - 1 - 4 - B4B		

**Container No:** S191418**Part:** D2806-3**Job No:** 196314**Serial No/Batch:** S191418**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's**Date:** 06/10/19

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				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
140 QC 7	20 pcs	7/12/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
150 Packaging 3-1 - Stock - B4B	20 pcs	7/12/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	

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					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	pc
					Packaging 3 - 24 - B4B	Stoll
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
160 QC 21 - SA	20 pcs	7/12/19	0.00 0.00		QC 21 - SA - 21	DAS
					QC 21 - SA - 70	21
					QC 21 - SA - 53	9-89

Part Op **100** - (Doosan Lathe) 1- Turn as per Folio FA105 Rev: _____ & Dwg D2806 Rev: _____
 Descriptions: **120** - (QC8- Inspect parts - second check)
130 - (Chemical Conversion Coat per QSI005 4.1)
140 - (QC7-Inspect Chemical Conversion Coat)
150 - (Identify as per dwg & Stock Location: _____)
160 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6H1.000	6061-T6 Hexbar 1.00	1.8320 ft (.0916 ea)	100-Doosan - 1	S150601

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Doosan - 1	M6061T6H1.000	2	10	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bushing	1.000Inches $\pm$ 0.010	1.010 0.990	1002	
2	Bushing	1.155Inches $\pm$ 0.010	1.165 1.145	Ref	✓
3	Bushing	0.250Inches $\pm$ 0.010	0.260 0.240	25	
4	Bushing	0.063Inches $\pm$ 0.010	0.073 0.053	056	Angle
5	Bushing	45.000Inches $\pm$ 0.000	45.000 45.000	450	
6	Bushing	0.080Inches $\pm$ 0.010	0.090 0.070	075	
7	Bushing	45.000Degrees $\pm$ 0.000	45.000 45.000	40	Angle
8	Bushing	0.495Inches + 0.000 - 0.005	0.495 0.490	4925	
9	Bushing	0.750Inches + 0.000 - 0.005	0.750 0.745	7475	Diameter
10	Bushing	0.316Inches + 0.005 - 0.001	0.321 0.315	318	Diameter
11	Bushing	0.094Inches $\pm$ 0.010	0.104 0.084	1093	

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					